Accept	vork Orde ecember-06-13	er ID 109 8:23:41 AM	935		*109	9935*						Page	1
Type of the content o	evision ID:	D2282-041		A	Accept	*N900	<b>040</b>	100	)* s		1.71	S1*	
Customer:  eference:  pprovals: Process Plan: MCD Date: /3-1/2-06 Tooling: Date:  QC: Date: SPC (Y/N): Date:  Stop *NR2*  QC: Date: SPC (Y/N): Date:  Accept Reject Reject Insp. Stamp  Draw Nbr Revision Nbr  QC: Rev E  QC: Reject Insp. Stamp  QC: Number Stamp  QC: Rev E  QC: Reject Insp. Stamp  QC: Reject Insp. Stamp  QC: Rev E  QC: Reject Insp. Stamp  QC: Rev E  QC: Reject Insp. Stamp  QC: Rev E  QC: Reject Insp. Stamp  Accept Reject Reject Reject Insp. Stamp  Accept Reject Reject Insp. Stamp  Accept Reject Reject Reject Insp. Stamp  Accept Reject Reject Insp. Stamp  Accept Reject Reject Reject Reject Reject Insp. Stamp  Accept Reject Reject Insp. Stamp  Accept Reject Reje	em Name:	T Assembly								Sto	p *N	S2*	
Process Plan: MCJ Date: 13-12-06 Tooling: Date:  QC: Date: SPC (Y/N): Date:  Stop *NR 2*  QC: Date: SPC (Y/N): Date:  Stop *NR 2*  QC: Date: SPC (Y/N): Date:  Stop *NR 2*  Tool ID Tool # Plan Accept Reject Reject Rumber Stamp  Run Hours  Accept Reject Reject Rumber Stamp  Run Hours  Number Stamp  1-Weld as per D2282-041 THandle Assembly Grind chamfers and ensure full penetration as per dwg D2282  ARER316L SS Filling Rod M125054  QC9- Inspect visual per QS1004- Fusion Welds 0.00  QC9- Inspect visual per QS1004- Fusion Welds 0.00  DAS  DAS  DAS  DAS	tart Date:	12/06/13	Start Qty: 50.00	*50*		Cust Item I	D:						
Process Plan: MCS Date: B-12-06 Tooling: Date: Stop *NR2*  QC: Date: SPC (Y/N): Date: Stop *NR2*  Accept Reject Reject Runbor Run Hours  Draw Nbr Revision Nbr  Draw Nbr Revision Nbr  Draw Nbr Revision Nbr  Draw Nbr Revision Nbr  1000  Large Fab Memo 0.00  1-Weld as per D2282-041 T Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282  ******brush weld right after welding, to take color off ******  ARER3161. SS Filling Rod M125054  QC9- Inspect visual per QSI004- Fusion Welds 0.00  QC9- Inspect visual per QSI004- Fusion Welds 0.00  DAS  DAS  DAS  DAS	equired Date:	12/20/13	<b>Req'd Qty:</b> 50.00	*50*		<b>Customer:</b>							
Process Plan: MLS Date: B-12-06 Tooling: Date:  QC: Date: SPC (Y/N): Date: Stop *NRS 7*  Aguence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Office Center ID Description Run Hours  Praw Nbr Revision Nbr  Revision Nbr  Large Fab  Memo 0.00  1-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282  ***The state of the color off *******  A/RER316L SS Filling Rod M12505-4  QC9- Inspect visual per QS1004- Fusion Welds 0.00  QC9- Inspect visual per QS1004- Fusion Welds 0.00  DAS  DAS  DAS  DAS  DAS  DAS  DAS  D	eference:									_			
QC: Date: SPC (Y/N): Date: Stop *NR2*  Squence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Operation Description Run Hours Code Qty Qty Number Stamp  Paw Nbr Revision Nbr  D2282 Rev E  O O O  Large Fab Memo O.00  I-Weld as per D2282-041 'T Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282  *********************************	pprovals:	Process Plan	1: MLJ	Date: 13-12-06	Tooling:	Da	ate:		R		1/1	R1*	
Revision Nbr Revision Nbr Rev E  OOO  Large Fab  Memo  1-Weld as per D2282-041 "T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282  *******brush weld right after welding, to take color off ******  A/RER316L SS Filling Rod_M125054  OOO  QC9- Inspect visual per QS1004- Fusion Welds  OOO  DAS  3  DAS  9			•							Sto	*N	R2*	
Revision Nbr  Revision Nbr  Rev E  0.00  Large Fab  Memo 0.00  1-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282 ******brush weld right after welding, to take color off ******  A/RER316L SS Filling Rod // 1125/05-4  QC9- Inspect visual per QSI004- Fusion Welds 0.00  DAS  110*	quence ID/ ork Center II	)				Tool ID	Tool #		-	-	•	-	
Large Fab  Memo  0.00  1-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282  ******brush weld right after welding, to take color off ******  A/RER316L SS Filling Rod M125054  QC9- Inspect visual per QS1004- Fusion Welds  0.00  DAS 9		Revi	sion Nbr										
Large Fab  Memo  1-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282  *******brush weld right after welding, to take color off ******  A/RER316L SS Filling Rod M125054  QC9- Inspect visual per QS1004- Fusion Welds  0.00  DAS 9	D2282	Rev	E										
Memo 0.00  I-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282  ******brush weld right after welding, to take color off ******  A/RER316L SS Filling Rod M125054  QC9- Inspect visual per QSI004- Fusion Welds 0.00  DAS  110*			J		0.00	alander of the second of the second for Fulfillian Aland							
I-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282 *******brush weld right after welding, to take color off ******  A/RER316L SS Filling Rod M129054  QC9- Inspect visual per QSI004- Fusion Welds 0.00  DAS 110*	100*		Large Fab						×35		13-12	-10	N
Grind chamfers and ensure full penetration as per dwg D2282  ******brush weld right after welding, to take color off ******  A/RER316L SS Filling Rod M125054   QC9- Inspect visual per QSI004- Fusion Welds 0.00  DAS  110*	ĭ		Memo		0.00				,				
110*	rge¶Fab		Grind chan *****brus	nfers and ensure full penetra h weld right after welding, t	ation.as per dwg D2282 to take color off ******								
0.00			QC9- Inspect visual per C	QSI004- Fusion Welds	0.00				Œ	12.1	212		
	'1110×												

120

\*120\* Small Fab

Small Fab

Memo

Tumble

0.00

0.00

35 Neg 13-11

Work Order ID 109935  December-06-13 8:23:42 AM				*10	9935*			Page
Item ID: Revision ID: Item Name:	D2282-041 T Assembly			Accept	*N900040100*	Setup	Start Stop	*NS1*
Start Date: Required Date Reference:		eq'd Qty: 50.00	*50* *50*		Cust Item ID: Customer:			14(3)
Approvals:	Process Plan: QC:		Date:	Tooling: SPC (Y/N):	Date:	Run	Start Stop	*NR1* *NR2*

Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Reject Reject Insp. Accept Work Center ID Number Stamp Description Run Hours DAS Code Qty Qty 0.00 QC5- Inspect part completeness to step on W/O \*120\* QC Memo Quality Control

Identify as per dwg & Stock Location \*1140\*

0.00

0.00

Memo

150

Packaging Packaging

QC21- Final Inspection - Work Order Release

0.00

\*150\* QC

Memo

0.00

Quality Control

.35

DAS 36 9-89

Page 2

Picklist Print

December-06-13 8:23:45 AM

Work Order ID: 109935

\*109935\*

D2282-041 Parent Item:

Parent Item Name: T Assembly

\*D2282-041\*

**Start Date: 12/06/13** 

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Required Date: 12/20/13

Page 1

**Start Qty: 50.00** 

Required Qty: 50.00

**Comments:** 

IPP Rev:A

Removed from 9 Digit

Manufactured

05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	1
D2282-3		Manufactured	No			100	Each	28.0000	1	50				-
*172282 2*									**					

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Tube

$\mathcal{B}$	104605	×	18
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<b>Location</b>	Loc	<b>Qty</b>	Loc Code
`WA001		28	
107670		17	
74969		11	
	100	Each	46 0000

+35 13-12-10 MAL 50

\*D2282-5\*

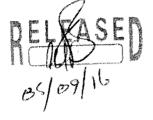
D2282-5

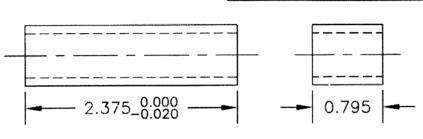
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74962	11	
WA002	35	
92093	35	

X35 13-12-10 MAC

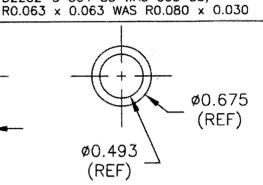


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	w	1000	D2282 SHEET 1 OF 2
DATE			TITLE SCALE
05.0	6.07		HANDLE TUBES 1:1
Α		94.10.14	NEW ISSUE
В		95.03.23	RE-DESIGN
С		97.10.20	CORRECTED NUMBERING SCHEME
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
_		05.06.07	D2282-5 304 SS WAS 303 SS;

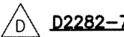




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D2282--3

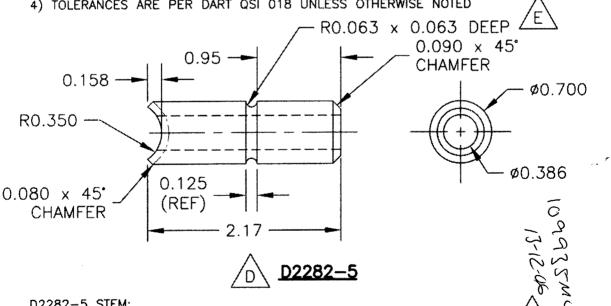


05.06.07

## D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



## D2282-5 STEM:

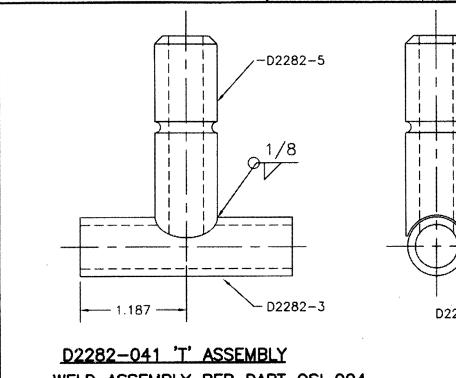
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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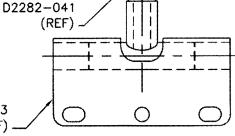
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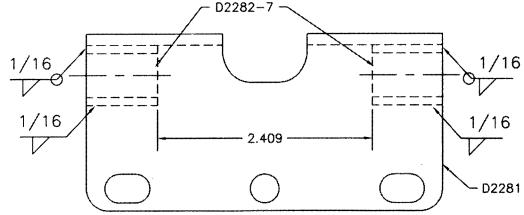
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u'	land	D2282	SHEET 2 OF 2				
DATE		TITLE	SCALE				
05.06.07		HANDLE TUBES	1:1				



WELD ASSEMBLY PER DART QSI 004



## GENERAL ASSEMBLY SCALE 1:2



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

D2282-043 (REF)

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